

Work Order ID 102366

102366

Page 1

May-28-13 8:43:41 AM

Item ID: D4092-1

Accept

Revision ID:

Item Name: Maintenance Step

Start Date: 5/27/13

Start Qty: 6.00

6

Required Date: 5/27/13

Req'd Qty: 6.00

6

Reference:

Approvals: Process Plan: MLJ

Date: 13-05-29

Tooling:

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr.	Revision Nbr								
-----------	--------------	--	--	--	--	--	--	--	--

D4092	B								
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100	Cut blanks as per folio	0.00							
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100

Bandsaw

Jeaspa Bandsaw

110

110

HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA935

Dwg Rev:

Folio rev:

Deburr

DAS
4/23/13 06:10 16
02/09

2013-06-15
02/09

15

Pto

NCR: Yes No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: SWL Date:

13/06/28

QA Closed: Open Date:

Work Order: <u>107366</u>	DISPOSITION				AGAINST DEPARTMENT/PROCESS				
Part No. <u>D4092-1</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. <u>13-2704</u>	Scrap <input checked="" type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	10/06/14	110	x1	part is measures 2.414 in 2.500 location (across top of step) .056" below tolerance RC. tried to re-pass Y2" endmill on part re-set Y1 origin instead of X origin	CP 13/6/14	SCRAP 13/06/14	CP 13/6/14	13/06/14	13/06/14
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced								
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure								
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld								
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled								
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Other								
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other								
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other								
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Other	<input type="checkbox"/> Other								
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Other	<input type="checkbox"/> Other								
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Other	<input type="checkbox"/> Other								
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Other	<input type="checkbox"/> Other								

Work Order ID 102366***102366***

Page 2

May-28-13 8:43:41 AM

Item ID: D4092-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Maintenance Step

Stop

NS2

Start Date: 5/27/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/27/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*DA
210213-06-14
69*

15 1

130

130

QC

Quality Control

QC8- Inspect parts - second check

0.00

*DA
13/06/17*

15 φ

*DA
08
98*

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

15 16 13-6-18

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
										<input type="checkbox"/> Other	

Work Order ID 102366

May-28-13 8:43:41 AM

102366

Page 3

Item ID: D4092-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step

Start Date: 5/27/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/27/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

155

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

125887.00

160

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

15

15 BL 136-18

170

170

Packaging

Packaging

Identify as per dwg & Stock Location

ST210A

0.00

13 6 18

15

15x

13-6-18

NCR: Yes / No

DQA: Date: ,

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>							
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector			
Doc/Data	<input type="checkbox"/>														
Equip/Tooling	<input type="checkbox"/>														
Operator	<input type="checkbox"/>														
Material	<input type="checkbox"/>														
Setup	<input type="checkbox"/>														
Other	<input type="checkbox"/>														
Process	<input type="checkbox"/>														
Supplier	<input type="checkbox"/>														
Training	<input type="checkbox"/>														
Unapproved	<input type="checkbox"/>														
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
												<input type="checkbox"/> Other			

Work Order ID 102366

102366

Page 4

May-28-13 8:43:41 AM

Item ID: D4092-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Maintenance Step

Stop

NS2

Start Date: 5/27/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/27/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

13/6/1988

180

QC

Quality Control

Memo

0.00

MLJ 13-06-19

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

Picklist Print

May-28-13 8:43:41 AM

Page 1

Work Order ID: 102366

Parent Item: D4092-1

Parent Item Name: Maintenance Step

Start Date: 5/27/13

Required Date: 5/27/13

Start Qty: 6.00

Required Qty: 6.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108 Extrusion (HPK)		Manufactured	No			100	f	674.9935	2.5	15.789473			

Location	Loc Qty	Loc Code
MAT007 80206	674.99354 674.99354	

BT 13-06-10

46.

NCR: Yes / No

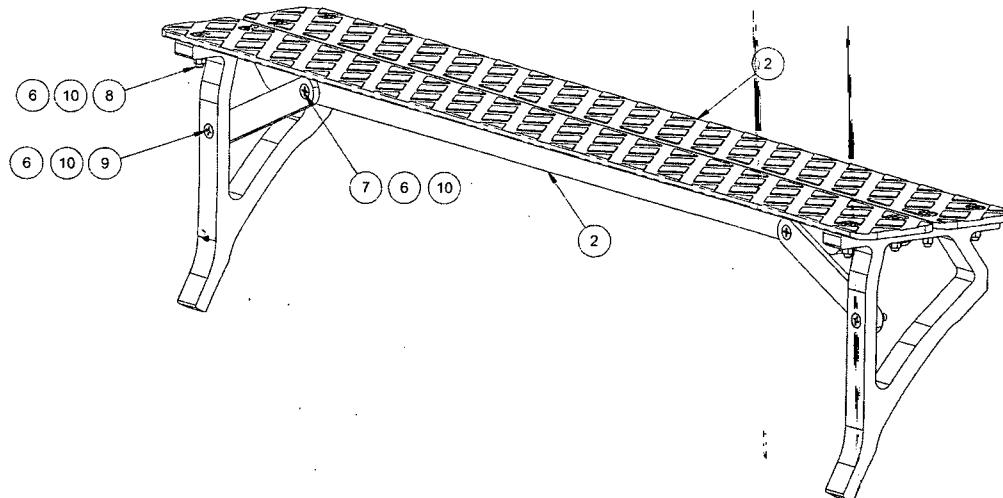
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS								
Part No. _____	<input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>								
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>														
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-041 MAINTENANCE STEP ASSEMBLY



SHEET 1 OF 1
 DRAWN BY
 ENGINERED BY
 UNCONTROLLED COPY
 SUBJECT TO APPROVAL
 WITHDRAWN
 APPROVAL NUMBER
 M4102366-MLS
 13-05-29

RELEASED
 2011-09-22
 MW

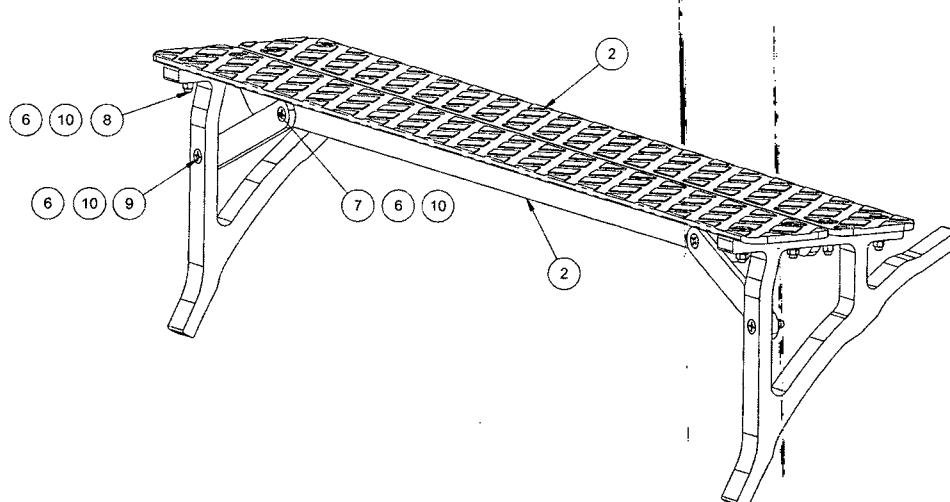
B	REDRAWN; LOWERED FOR AESTHETICS		RF	11.07.27
A	NEW ISSUE		RF	10.09.16
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	KENT, WA		
CHECKED	140	DRAWING NO.		
MFG. APPR.	9/1	D4092		
APPROVED	140	REV. B		
DE APPR.	9/1	SHEET 1 OF 6		
DATE	11.07.27	TITLE	SCALE	NTS
		MAINTENANCE STEP ASSY		

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8 7 6 5 4 3 2 1

102366

ITEM #	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY



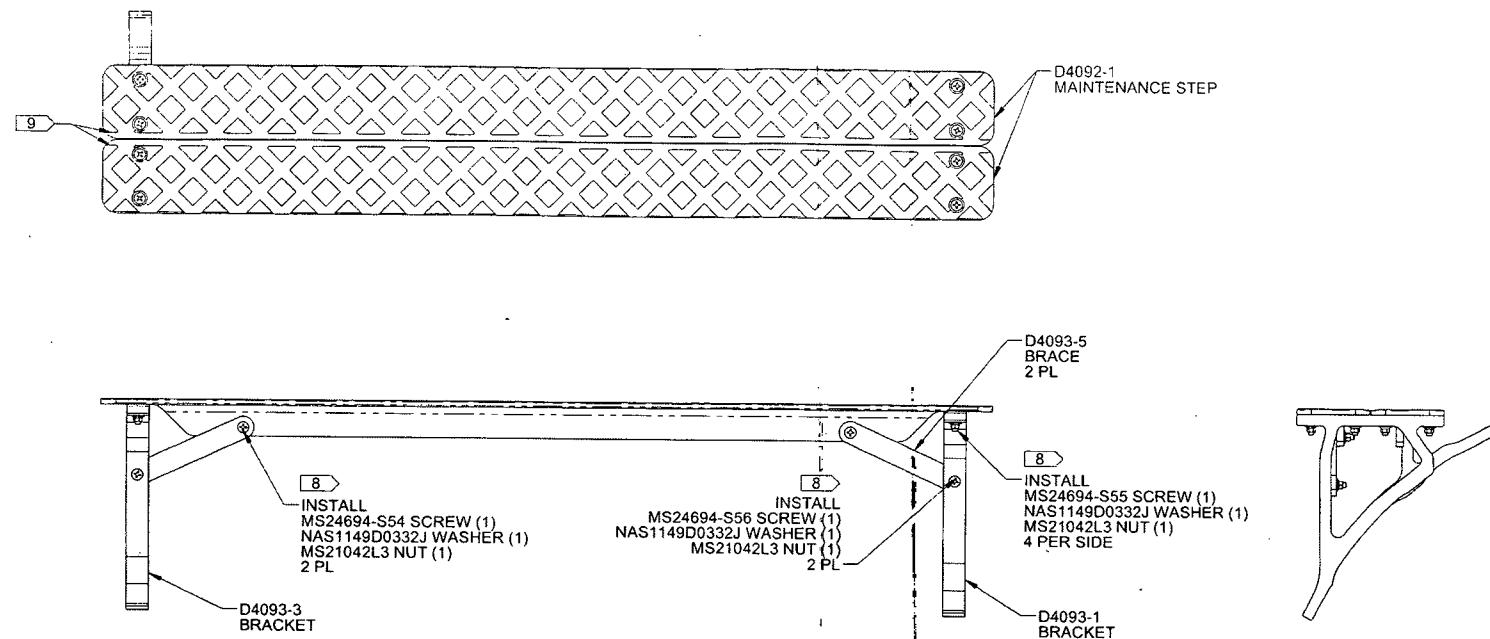
RELEASED
2011-09-22
JW

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	KENT, WA
CHECKED	MP	DRAWING NO.
MFG. APPR.	MP	REV. B
APPROVED	MP	D4092
DE APPR.	MP	SHEET 2 OF 6
DATE	11.07.27	TITLE
		MAINTENANCE STEP ASS'Y
		NTS

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8 7 6 5 4 3 2 1

102366



D4092-041 MAINTENANCE STEP ASSEMBLY

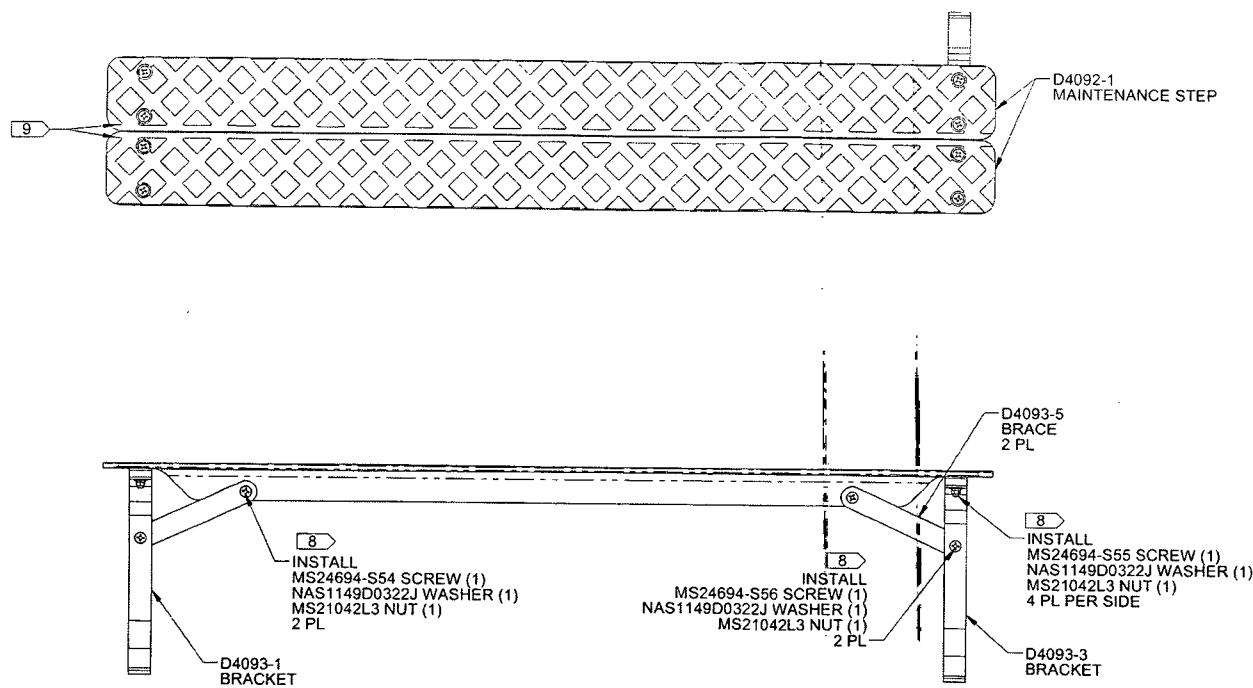
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>mp</i>	DRAWING NO.	
MFG. APPR.	<i>gj</i>	D4092	REV. B
APPROVED	<i>mp</i>		SHEET 3 OF 6
DE APPR.	<i>mp</i>		TITLE
DATE	11.07.27	MAINTENANCE STEP ASSY	SCALE
			NTS

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RELEASED
2011-09-22
mp



D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

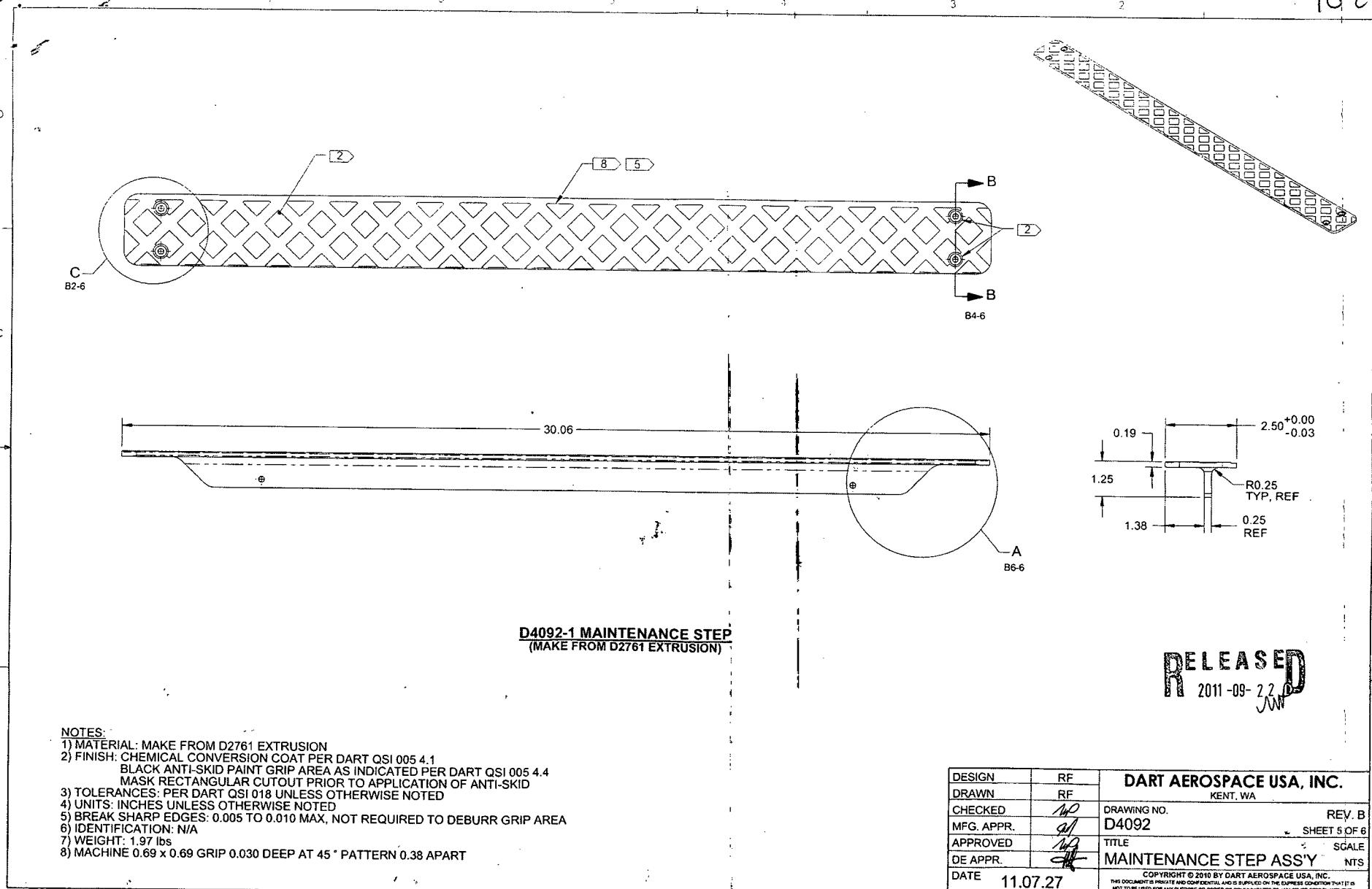
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	
MFG. APPR.	<i>gj</i>	REV. B	
APPROVED	<i>140</i>	D4092	
DE APPR.	<i>140</i>	SHEET 4 OF 6	
DATE	11.07.27	TITLE	
		MAINTENANCE STEP ASSY	
		NTS	

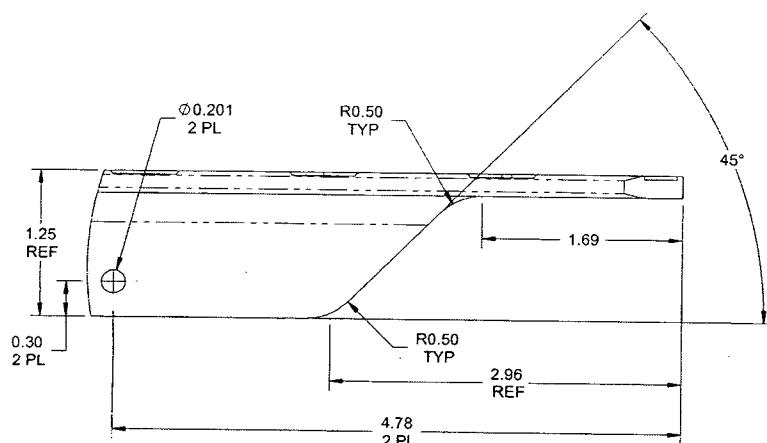
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R 2011-09-22
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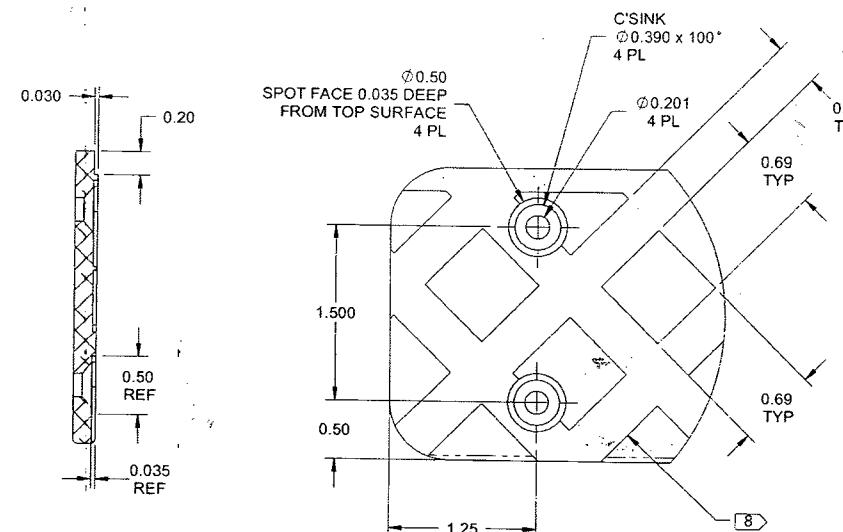
102366



102366



DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP

DETAIL C C8-5
SCALE 3X, TYP

RELEASED
2011-08-22
MM

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	KENT, WA
CHECKED		DRAWING NO.
MFG. APPR.		D4092
APPROVED	DE APPR.	REV. B
		SHEET 6 OF 6
DATE	11.07.27	TITLE
		MAINTENANCE STEP ASS'Y
		NTS

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DART AEROSPACE LTD		Work Order:	102366
Description: Maintenance Step		Part Number:	D4092-1
Inspection Dwg: D4092	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30.060	✓		Type	BT-10
0.19	+/-0.030	.192	✓		view	BT-4
1.25	+/-0.030	1.245	✓		height gauge	31006
1.38	+/-0.030	1.371	✓			
0.25	+/-0.030	.248	✓			
R0.25	+/-0.030	.250	✓			
2.50	+/-0.030	2.486	✓			
Ø0.201	+0.005/-0.001	.202	✓			
0.30	+/-0.030	.291	✓			
4.78	+/-0.030	4.775	✓			
1.69	+/-0.030	1.690	✓			
2.96	+/-0.030	2.96	✓			
0.030	+/-0.010	.034	✓		depth gauge	BT-6
0.20	+/-0.030	.199	✓			
0.50	+/-0.030	.498	✓			
0.035	+/-0.010	.032	✓			
0.390 x 100°	+/-0.010 x 0.5°	.387	✓			
1.500	+/-0.130	1.506	✓			
0.50	+/-0.030	.499	✓			
1.25	+/-0.030	1.253	✓			
0.69	+/-0.030	.684	✓			
0.38	+/-0.030	.378	✓			
0.69	+/-0.030	.684	✓			

DA _o	DAS	Preliminary Approval:
Measured by: BT 02	Audited by: M.A. 08	Date:
Date: 13-06-14	Date: 13/06/14	Date:

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	GT